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DART AEROSPACE LTD	Work Order :	21914
Description: Console Side RH (407 Hi-Slope)	Part Number:	D2604-2
Note: Issue with Part Number D2604-1		
Drawing: D2604 Rev. A1 04.11.17	Qty:	9 72

Stack of 10 RF 02/05/10

QTY

10

Step	Location	Procedure	By	Date
1	EXPEDITING	Issue W/O	JL	04.11.17
2	CNC CELL / METAL	Cut Blank per template DT 8247 Note: 1 Blank makes: D2604-1(Qty: 1), D2604-2(Qty: 1) Material: .040 - 2024-T3 Batch B15919	EC	04.11.22
3	HAAS	Machine per folio D2604	ml	04.11.23
4	QC	Inspect Level 2	ml	04.11.23
5	QC	Inspect Level 8	EC	04.11.24
6	METAL	Form per Dwg D2604	Z	04.12.09
7	QC	Inspect Level 5	M	04.12.09
8	FINISHING	Acid etch & alodine as per QSI 005	Z	04.12.09
9	STORES	Identify and stock	ml	04.12.13
10	EXPEDITING	Close W/O Inspect level 21 Cost / part 20.13 Sur 04/12/14 (9) 20.13	JL	05.01.13

Rev	Date	Change	Revised By	Approved
A	96.07.27	New Issue		
B	98.05.08	Added drawing revision	KB	
C	98.11.25	Added Inspection Levels, Jig numbers	DM	
D	02.06.05	Added alodine finish TSR 1290	NG	C.E 3/6/05

3b GA deburr

RELEASED

02/06/05

ml 04.11.04 10/91

PTO

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
04-11-24	3b	Permanent change to the 3b - debur - must be on the front	JML	04-12-21	N/A	B perior	B on 12/15	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
04-11-24	3b	Found 1X D2604-1 Bad Kink	04-11-24	destroy it	MJL 04-11-24	04-12-15	B perior	B on 12/15
		↑ NOTE: S/B. D2604-1 See w/o		21913.				

Part No: D2604-2

PAR #: _____

Fault Category: _____

NCR: Yes DQA:

Date: 05/01/13

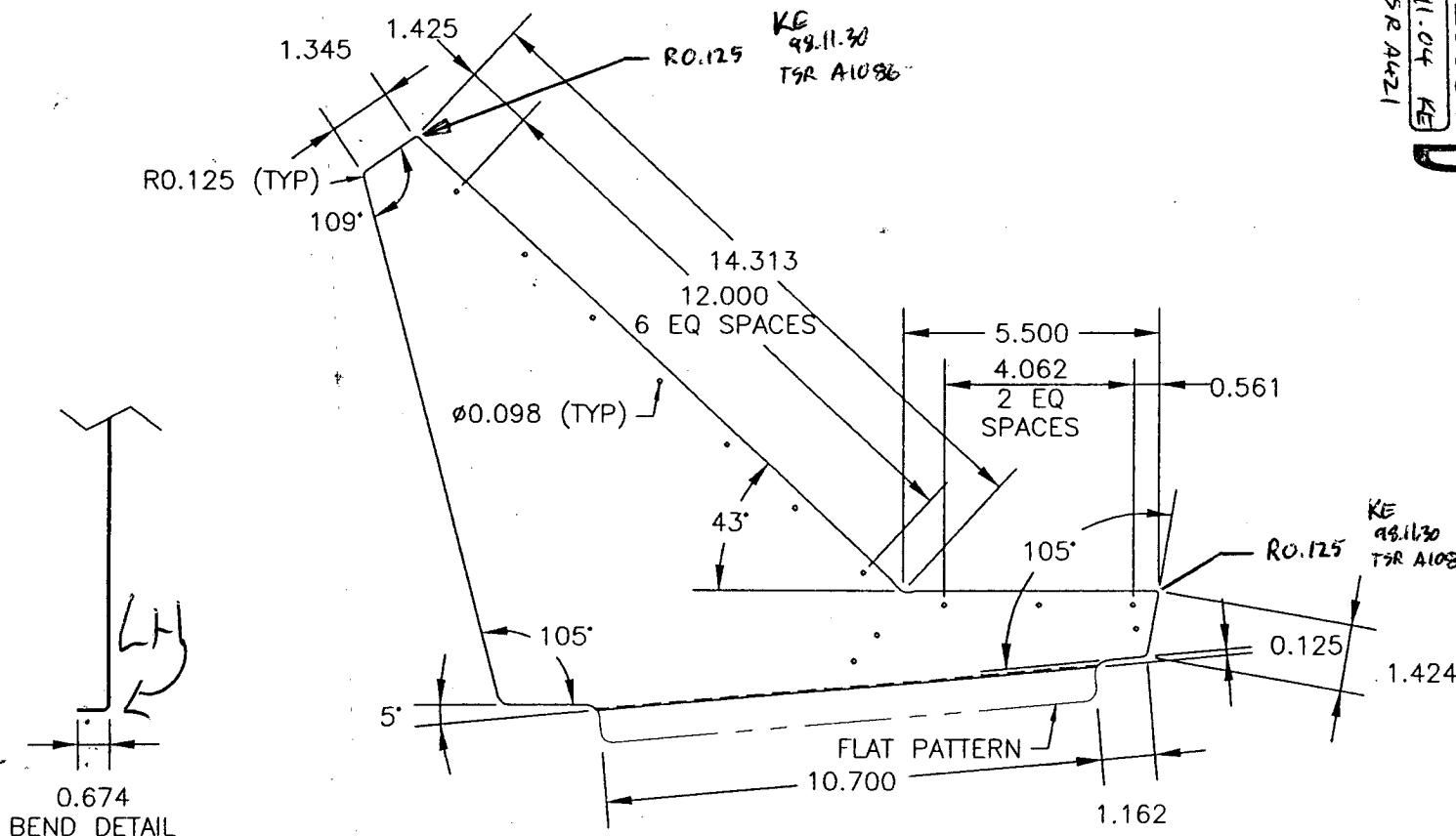
NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CH KE	APPROVED	VICTORIA INTERNATIONAL AIRPORT, CANADA	
DATE	DRAWING NO.	REV. A	SHEET 1 OF 1
97.10.24	D2604		
A1	97.10.24	D2604 WAS D206-547-23/-24	SCALE 1:4

RELEASED
97.11.04 KE
TSR ACK21

MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK
PROFILE CONTROLLED BY FOLIO H2604

BEND RADIUS 0.093

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 A1

D2604-1 SHOWN

D2604-2 OPPOSITE

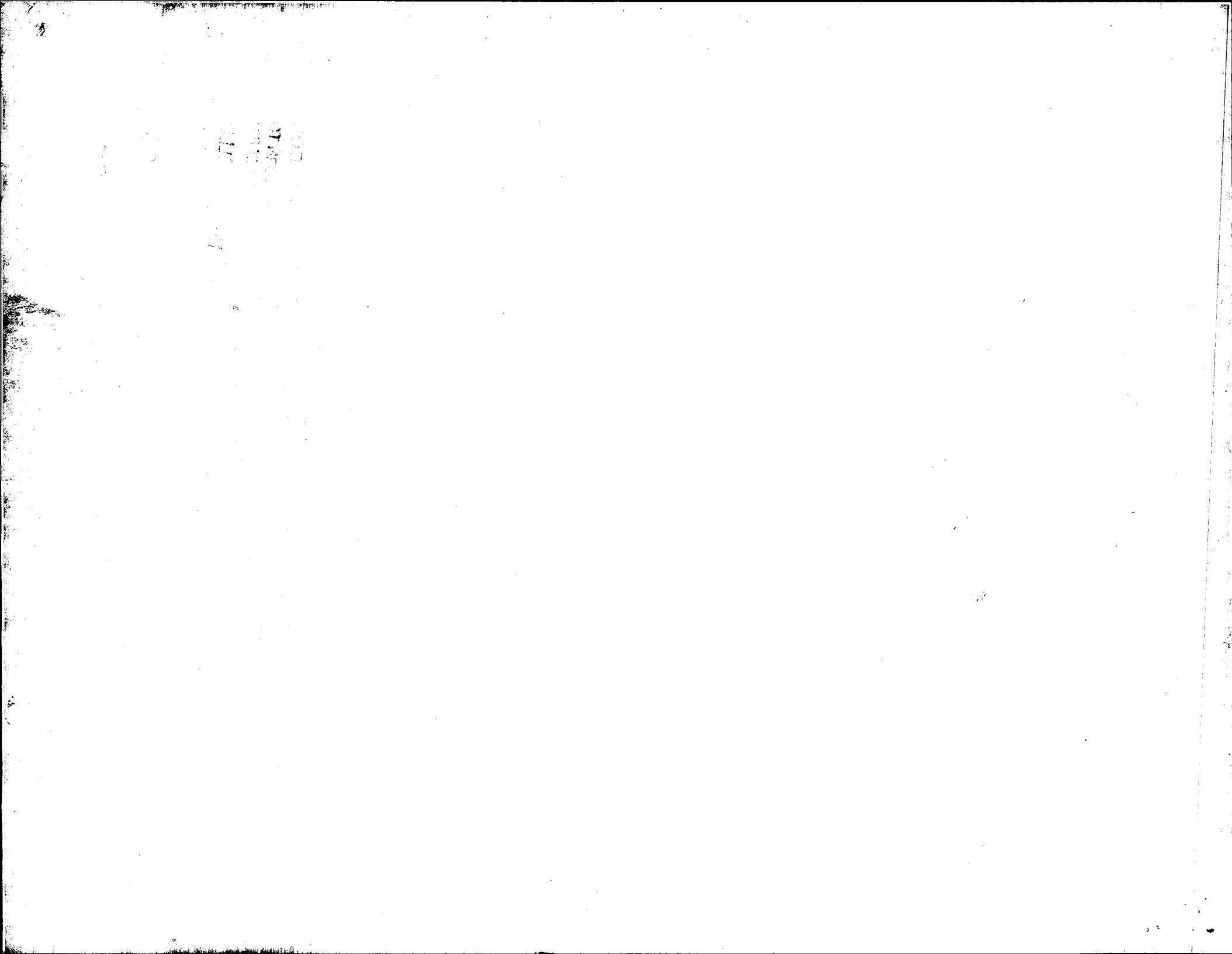
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 2194

SHOP COPY

RETURN TO

ENGINEERING



Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 17, 2004
07:47 am

Work Order No : 0021914
 Project Name : D2604-2
 Project For : WK450
 Work Order Type : Main
 Main WO Number :
 House Part Number : D2604-2
 Description : 407 Hi Console Side RH
 Manufactured : Yes
 Amount Req'd : 10
 Amount Done : 0
 Start Date : 11-16-04
 Est Finish Date : 12-04-04
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd :
 Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 Est Margin : 0.000%
 Actual Margin : 0.000%
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00	0.00	0.00
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00	0.00	0.00
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00	0.00	0.00
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00	0.00	0.00
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00	0.00	0.00
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00	0.00	0.00
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00	0.00	0.00
Total Cost :	0.00	0.00	0.00	0.00	0.00
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00

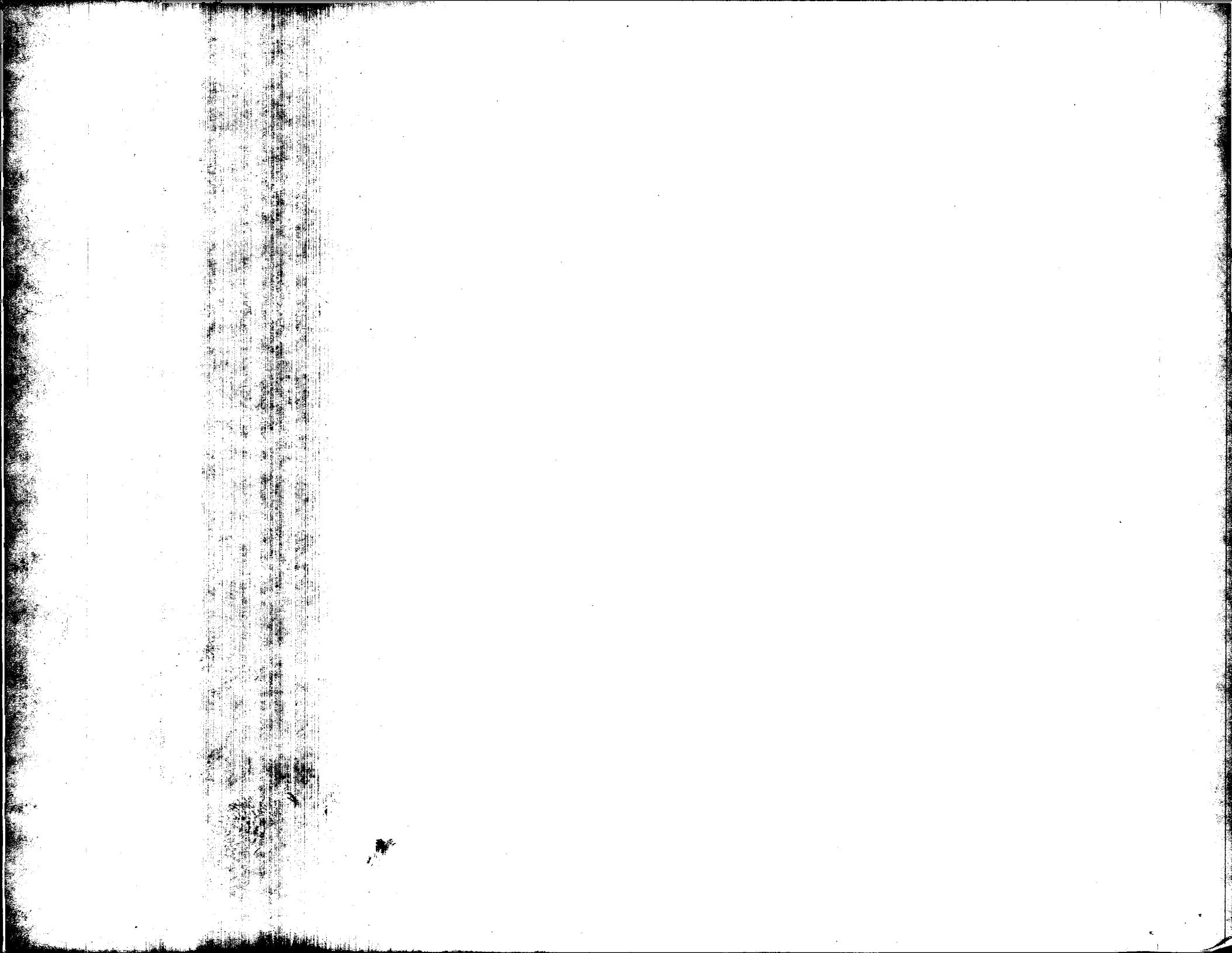
DART AEROSPACE LTD	Work Order:	21914
Description: Console Side RH (407 H; -Slope)	Part Number:	D2601-2
Inspection Dwg: D2604 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	
Date:		Date:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



DART AEROSPACE LTD	Work Order:	21913
Description: Console Side LH (407 Hi-Slope)	Part Number:	D2604-1
Inspection Dwg: D2604 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>932</u>	Audited by:	<u>E</u>	Prototype Approval:	<u>NA</u>
Date:	<u>04/11/23</u>	Date:	<u>04.11.23</u>	Date:	<u></u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

